

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005184**Date Inspected:** 29-Dec-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Fu Guo gang	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes No N/A	Approved WPS:	Yes	No N/A
		Delayed / Cancelled:	Yes	No N/A
Bridge No:	34-0006	Component:	Tower Components	

Summary of Items Observed:

On the date Caltrans OSM Quality Assurance (QA) inspector Mike Blair was present during the times noted above for observations relative to the work being performed.

Bay 10-Tower**Ultrasonic Testing**

The QA Inspector performed Ultrasonic Testing (UT) on approximately 25% of the area previously tested and accepted by ZPMC Quality Control personnel. The QA Inspector generated an Ultrasonic report for this date. The member is identified as NSD1-SA61A/G. The weld designations are as follows: 3

Sub Arc

This QA Inspector observed the following work in process: SAW welding of weld joint 4 located on NSD1 SA171C/D. Welder is identified as 42195. ZPMC QC is identified as Tom. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-U3c-S-2.

Bay 11-Tower**Ultrasonic Testing**

The QA Inspector performed Ultrasonic Testing (UT) on approximately 25% of the area previously tested and accepted by ZPMC Quality Control personnel. The QA Inspector generated an Ultrasonic report for this date. The member is identified as WSD1-SA388A/D. The weld designations are as follows: 5 and 8.

Ultrasonic Testing

WELDING INSPECTION REPORT

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The QA Inspector performed Ultrasonic Testing (UT) on approximately 25% of the area previously tested and accepted by ZPMC Quality Control personnel. The QA Inspector generated an Ultrasonic report for this date. The member is identified as WSD1-SA49A/D. The weld designations are as follows: 24, 25, and 26.

Fit-up

This QA Inspector observed in-process Flux Core Arc Welding (FCAW) tack welding and fit-up of longitudinal stiffener plate's on WSD1-SA77A/F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Blair, Mike	Quality Assurance Inspector
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Reviewed By:	Clifford, William	QA Reviewer
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